

**Work Order ID 50979**

July 28, 2009 1:55:28 PM



Page 1

Item ID: D212-664-107TRN

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/30/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



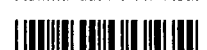
QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D212-664-147

Rev A

100

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio  
FA705□2-Turn first side as per Folio FA113□3-File down transition lines  
smooth.

Q.m 09-10-09 ①

110

0.00



QC

QC1- Inspect dimensions to dimension sheet

Memo

0.00

Quality Control

Q.m 09-10-09 ①

120

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA705□2-File down transition lines smooth.  
□  
3- Remove plugs and sand

Q.m 09-10-09 ①

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 50979**

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Item ID: D212-664-107TRN

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/30/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

|     |  |      |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|
| 130 | QC1- Inspect dimensions to dimension sheet | 0.00 |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|



|    |      |      |  |  |  |  |  |  |  |
|----|------|------|--|--|--|--|--|--|--|
| QC | Memo | 0.00 |  |  |  |  |  |  |  |
|----|------|------|--|--|--|--|--|--|--|

Quality Control

Am 09-10-07 ①

|     |                                   |      |  |  |  |  |  |  |  |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|
| 140 | QC8- Inspect parts - second check | 0.00 |  |  |  |  |  |  |  |
|-----|-----------------------------------|------|--|--|--|--|--|--|--|



|    |      |      |  |  |  |  |  |  |  |
|----|------|------|--|--|--|--|--|--|--|
| QC | Memo | 0.00 |  |  |  |  |  |  |  |
|----|------|------|--|--|--|--|--|--|--|

Quality Control

1 - ① - Am 09-10-08

|     |                                |      |  |  |  |  |  |  |  |
|-----|--------------------------------|------|--|--|--|--|--|--|--|
| 150 | Crosstubes Chemical Conversion | 0.00 |  |  |  |  |  |  |  |
|-----|--------------------------------|------|--|--|--|--|--|--|--|



|            |      |      |  |  |  |  |  |  |  |
|------------|------|------|--|--|--|--|--|--|--|
| HandFXtube | Memo | 0.00 |  |  |  |  |  |  |  |
|------------|------|------|--|--|--|--|--|--|--|

Hand Finishing Crosstubes

Am 09-10-08 ①

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 50979

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Page 3

Item ID: D212-664-107TRN

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/30/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

160

QC3- Inspect Part Finish

0.00



2) 8/01/10/13

QC

Memo

0.00

70

φ

Quality Control

170

Packaging

0.00



0.00

Packaging

Memo

Identify and stock in kanban rack ☐ Location: X-TUBE CELL

1 φ - AWM 9-10-13

180

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

09/10/14

MF 09-10-13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

July 28, 2009 1:55:27 PM

Page 1

Work Order ID: 50979

Parent Item: D212-664-107TRNRevA

Parent Item Name: Crosstube Turning Detail


Comments:

Start Date: 7/30/09

Required Date: 8/07/09

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D6019-128RevA  |                        | Manufactured  | No          |                     |                  | 110             | Each               | 22.0000        | 1.0000                   |               |                |        |
|  |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |
| Crosstube Material   |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

09-10-09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

22

29369

7

32310

15

\_\_\_\_\_

\_\_\_\_\_

\_\_\_\_\_

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|  |  |                                  |
|--|--|----------------------------------|
| <b>DART AEROSPACE LTD</b>                                    |  | <b>Work Order:</b> 50979         |
| <b>Description:</b> Crosstube Assembly (205/212/412 Low Fwd) |  | <b>Part Number:</b> D212-664-147 |
| <b>Inspection Dwg:</b> D212-664-147 <b>Rev:</b> A            |  | <b>Page 1 of 1</b>               |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

|        | Inspection Sheet<br>Drawing Dimension | Tolerance     | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|--------|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 0.313                                 | +/-0.010      | 0.313               | /      |        |                         |          |
|        | 2.360                                 | +0.005/-0.000 | 2.365               | /      |        |                         |          |
|        | 2.360                                 | +0.005/-0.000 | 2.365               | /      |        |                         |          |
|        | 2.366                                 | +0.005/-0.000 | 2.371               | /      |        |                         |          |
|        | 2.473                                 | +0.005/-0.000 | 2.478               | /      |        |                         |          |
|        | 2.573                                 | +0.005/-0.000 | 2.578               | /      |        |                         |          |
|        | 2.673                                 | +0.005/-0.000 | 2.678               | /      |        |                         |          |
|        | 2.750                                 | +0.005/-0.000 | 2.750               | /      |        |                         |          |
|        | 2.750                                 | +0.005/-0.000 | 2.752               | /      |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |
| SIDE B | 0.313                                 | +/-0.010      | 0.313               | /      |        |                         |          |
|        | 2.360                                 | +0.005/-0.000 | 2.364               | /      |        |                         |          |
|        | 2.360                                 | +0.005/-0.000 | 2.365               | /      |        |                         |          |
|        | 2.366                                 | +0.005/-0.000 | 2.371               | /      |        |                         |          |
|        | 2.473                                 | +0.005/-0.000 | 2.478               | /      |        |                         |          |
|        | 2.573                                 | +0.005/-0.000 | 2.578               | /      |        |                         |          |
|        | 2.673                                 | +0.005/-0.000 | 2.678               | /      |        |                         |          |
|        | 2.750                                 | +0.005/-0.000 | 2.753               | /      |        |                         |          |
|        | 2.750                                 | +0.005/-0.000 | 2.758               | /      |        |                         |          |
|        |                                       |               |                     |        |        |                         |          |
|        | 0.126.53                              | +/-0.020      | 126.550             | /      |        |                         |          |

|                        |                        |                            |     |
|------------------------|------------------------|----------------------------|-----|
| <b>Measured by:</b> am | <b>Audited by:</b> AWM | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 08-10-07  | <b>Date:</b> 9-10-08   | <b>Date:</b>               | N/A |

| Rev | Date     | Change                       | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A   | 08.11.07 | New Issue (P/O D212-664-107) | KJ/EC      |          |

**PARTS LIST:**

| Qty | Part Number       | Description   |
|-----|-------------------|---|
| X   | D212-664-147      | CROSSTUBE ASSEMBLY (205/212/412 LOW FWD)  |
| 1   | D6019-128         | CROSSTUBE   |
| 2   | D2893-1           | SUPPORT   |
| 4   | D3595-063-450     | RUBBER CUSHION  |
| 2   | D3659-1           | CUFF  |
| 4   | MS21920-25        | CLAMP (OR MS21920-26)   |
| 44  | CR3212-4-06       | RIVET (OR M7885/3-4-06)   |
| A/R | MAGNOBOND 6398    | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |
| A/R | SIKAFLEX-241/-291 | SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)   |

u/o  
50979

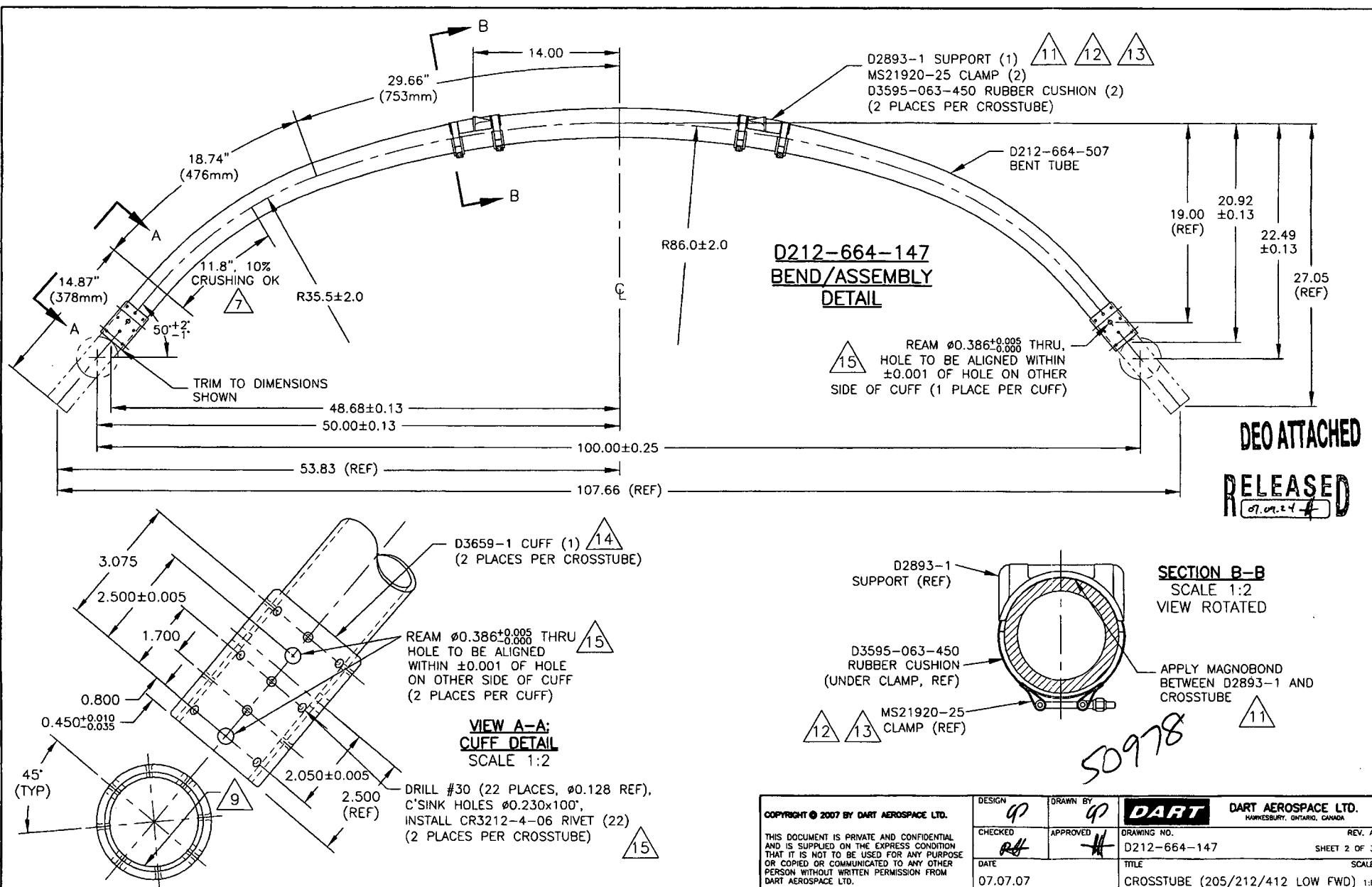
**GENERAL NOTES:**

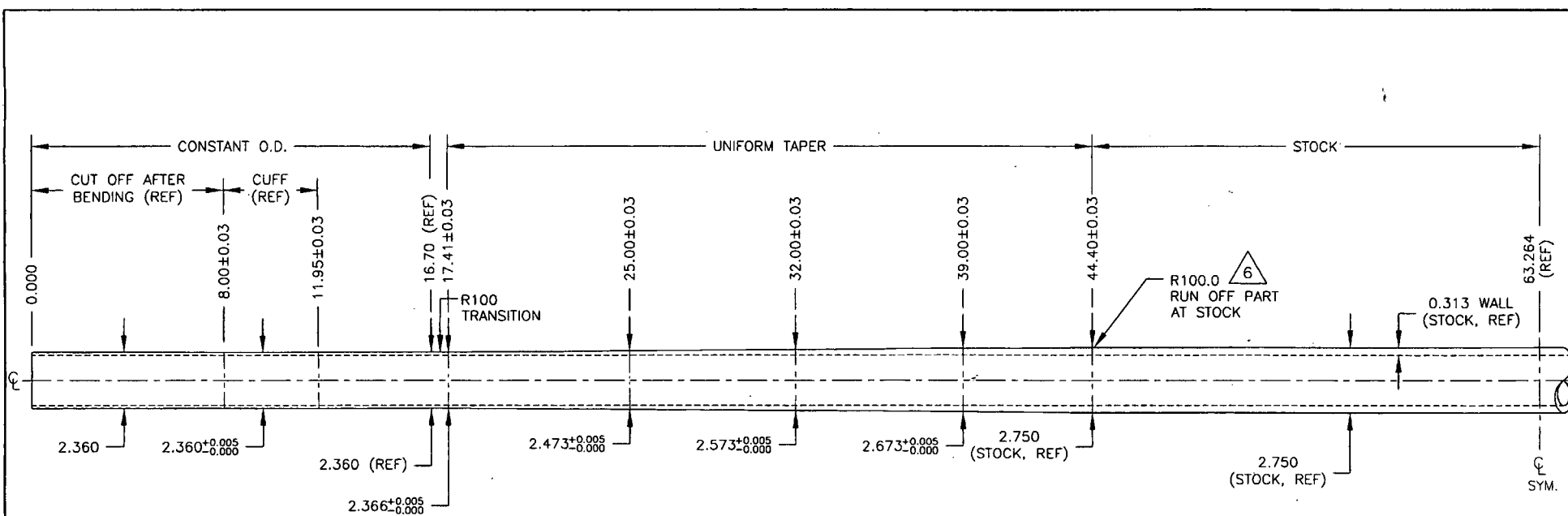
- 1) MATERIAL: MANUFACTURED FROM D6019-128  
FINISHED LENGTH = 126.53±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3659-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

DEO ATTACHED

RELEASED  
07.09.24

|  |   |  |           |
|--|---|--|-----------|
| A  |   | 07.07.07   | NEW ISSUE |
| DESIGN   | q | DRAWN BY   | q         |
| CHECKED  |   | APPROVED   | #         |
| DATE   |   | 07.07.07   |           |
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|  |   | SHEET 1 OF 3                                       |           |
|  |   | SCALE  |           |
|  |   | CROSSTUBE (205/212/412 LOW FWD) NTS                |           |





# D212-664-147 MACHINING DETAIL

RELEASED

DEO ATTACHED

50978

|  |  |                                     |          |              |   |
|--|--|-------------------------------------|----------|--------------|---|
| COPYRIGHT © 2007 BY DART AEROSPACE LTD.  |  | DESIGN                              | DRAWN BY | <b>DART</b>  | DART AEROSPACE LTD.<br>MARKHAM, ONTARIO, CANADA |
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| DATE   |  | 07.07.07                            |          | D212-664-147 | SHEET 3 OF 3                                    |
| TITLE  |  | CROSSTUBE (205/212/412 LOW FWD) 1:4 |          |              |   |

|                             |                      |                        |   |  |                                |                           |              |
|-----------------------------|----------------------|------------------------|---|--|--------------------------------|---------------------------|--------------|
| DRAWING NO.<br>D212-664-147 | TITLE<br>CROSSTUBE   | REV. A                 | DART AEROSPACE LTD<br>ENGINEERING ORDER |  | D.E.O. NO.<br>D212-664-147-A-1 | SHEET NO.<br>SHEET 1 OF 1 | SCALE<br>NTS |
| DRAWN<br><i>CD</i>          | CHECKED<br><i>PH</i> | MFG. APPR.<br><i>E</i> | APPROVED<br><i>MD</i>                   |  | DE APPR.<br><i>PH</i>          |                           |              |
| DATE<br>09.05.01            | DATE<br>09.06.15     | DATE<br>09.06.15       | DATE<br>09/06/16                        |  | DATE<br>09/06/16               |                           |              |

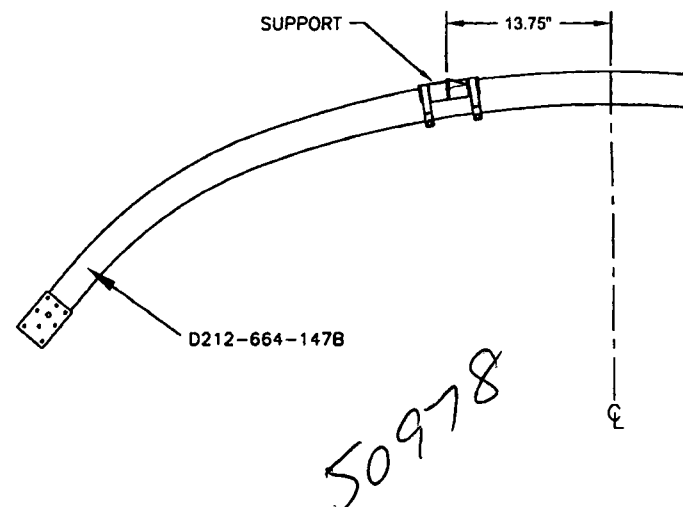
**CHANGE:**

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

| Part Number   | Description                      |
|---------------|----------------------------------|
| D212-664-147B | CROSSTUBE ASSEMBLY (214 LOW FWD) |

THE D212-664-147B CROSSTUBE HAS THE SAME PARTS LIST AS THE D212-664-147 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D212-664-147 CROSSTUBE.

**RELEASED**  
09/06/22 *MD*



**FIGURE 1 - SUPPORT INSTALLATION**